

Date: Monday, 6/25/2007 9:11:11 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARMOR SHIELD
Job Number : 33128	
Estimate Number : 12380	
P.O. Number : N/A	Part Number : D407667205A
This Issue : 6/25/2007 S.O. No. : N/A	Drawing Number : DSI9326
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : A
Previous Run : 31724	Material : N/A
Written By : _____	Due Date : 7/12/2007 Qty: 1 Um: Each
Checked & Approved By : <u>07.06.25</u>	
Comment : Est Rev: A New Issue 06-04-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD407-667-205A CHG002
 Add DSI 9326 to existing paper work.

2.0	D407667205	AFT Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ACT ~~Fwd~~ Crosstube

Batch: 31040

MM 07 07 04

(1)

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 1-Remove tube from packaging

2-Apply Armor shield as per DSI 9326

A/R Armor Shield Batch: 110453

MM 07 07 04

(1)

4.0	QC14	INSPECT SPRAY PAINT
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Comment: Inspect Spray Paint

RT 07 07 05

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-667-205A

Location: _____

PPP Rev: _____

Rev A 7/7/5 SP E/S 07/17/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMOR SHIELD

Job Number: 33128

Part Number: D407667205A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

2007/06

Job Completion



il 07/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J.J.</i>	APPROVED <i>A</i>	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14		TITLE ARMOR SHIELD	SCALE NTS
A	06.02.14	NEW ISSUE	

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101/-201 D412-664-203	SH01-9	SR01298NY
D206-667-101/-103/-201/-203 D407-667-105/-205	SH01-5	SR01304NY
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

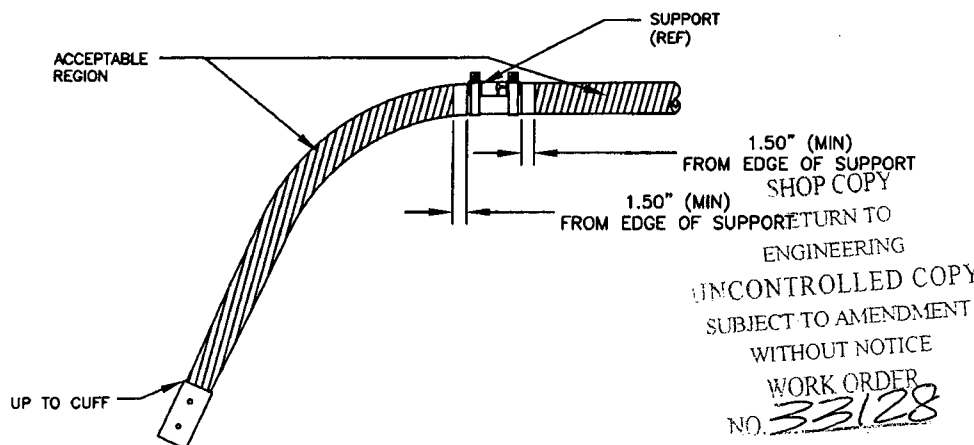


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i> BY: <u>D. SHEPHERD (DE # 02)</u>	
DATE:	06.02.14
CERT. NO.:	SH03-6/SH01-9/SH01-5
ISSUE NO.:	3/3/3

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